



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2739

Job Sheet 171264



Part No: D2739

Job Qty: 7 ea *10*

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

DAG
21
5-30

JAN 30 2018

Due Date: 2/9/18

Type: SOLD

Description:

Note: DWG REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28
As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per rev E DD ver: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	7 Ea		2/8/18	0.00	0.00	Start Up Skid tubes-2		<i>3/4</i>
100	Skid tubes	7 pcs		2/8/18	0.00	3.78	Skid tubes-3		<i>3/4</i>
120	HandFinish	7 pcs		2/9/18	0.00	0.58	HandFinish1		<i>28/12/02/09</i>
130	QC	7 pcs		2/9/18	0.00	0.00	QC5		<i>06</i>
140	Packaging	7 pcs		2/9/18	0.00	0.00	Packaging3-1		<i>06</i>
150	QC21-SA	7 Ea		2/9/18	0.00	0.00	QC21		<i>06</i>

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Descriptions: Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	7 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-5-108 <i>BU45248</i>	<i>10</i>	138	0

DART
AEROSPACE
S040307

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350 I – Beam

PART NO: D2739
Original Serial #: S040307
Revision:
Operation: Start up Operation
Change No:

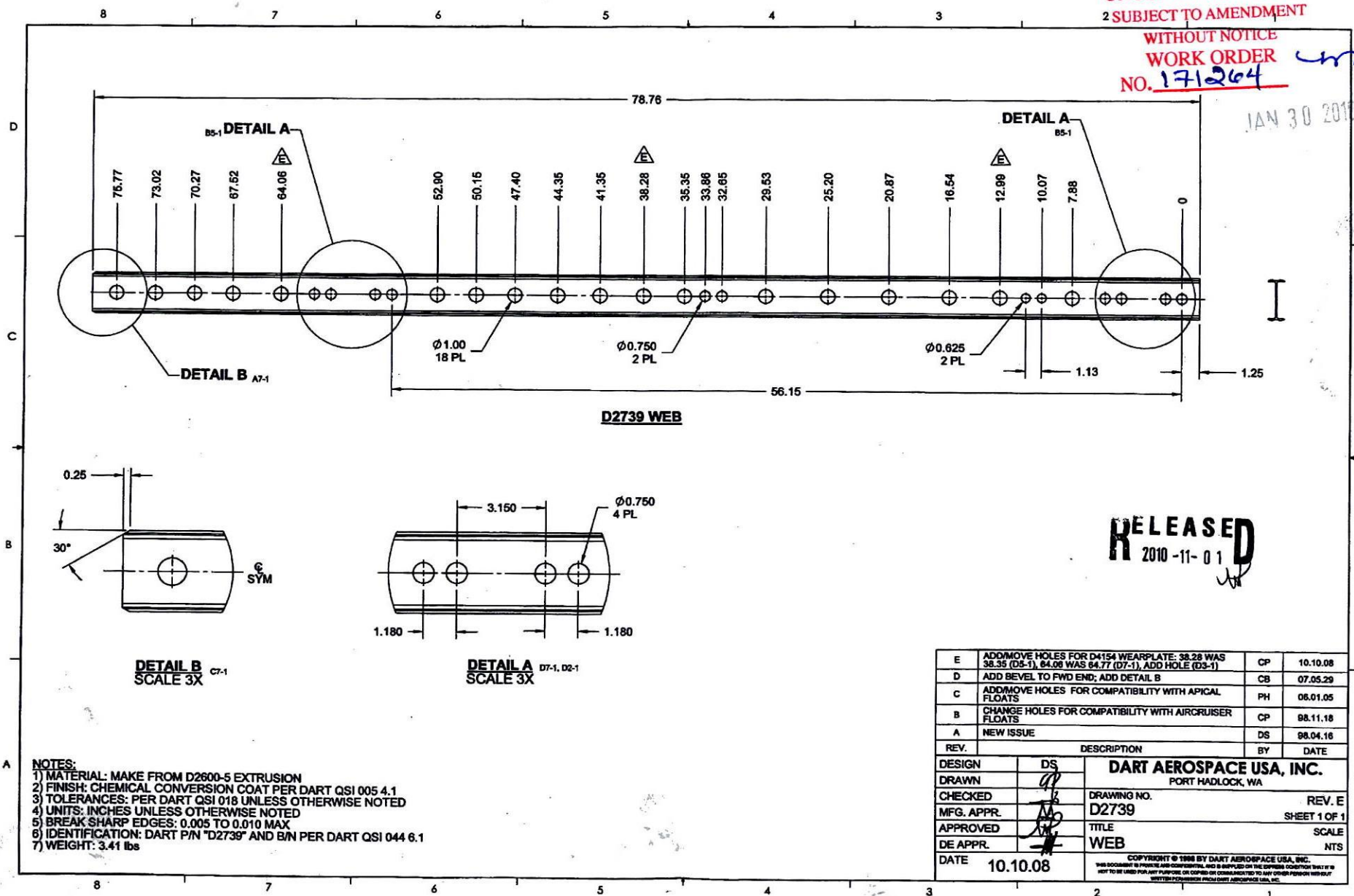
02/07/18
Job No: 171264

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730		
2	Web	1.180Inches ± 0.010	1.190 1.170		
3	Web	3.150Inches ± 0.010	3.160 3.140		
4	Web	1.180Inches ± 0.010	1.190 1.170		
5	Web	0.250Inches ± 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches ± 0.030	1.280 1.220		
8	Web	7.880Inches ± 0.030	7.910 7.850		
9	Web	10.070Inches ± 0.030	10.100 10.040		
10	Web	12.990Inches ± 0.030	13.020 12.960		
11	Web	16.540Inches ± 0.030	16.570 16.510		
12	Web	20.870Inches ± 0.030	20.900 20.840		
13	Web	25.200Inches ± 0.030	25.230 25.170		
14	Web	29.530Inches ± 0.030	29.560 29.500		
15	Web	32.650Inches ± 0.030	32.680 32.620		
16	Web	33.860Inches ± 0.030	33.890 33.830		
17	Web	35.350Inches ± 0.030	35.380 35.320		
18	Web	38.280Inches ± 0.030	38.310 38.250		
19	Web	41.350Inches ± 0.030	41.380 41.320		
20	Web	44.350Inches ± 0.030	44.380 44.320		
21	Web	47.400Inches ± 0.030	47.430 47.370		
22	Web	50.150Inches ± 0.030	50.180 50.120		
23	Web	52.900Inches ± 0.030	52.930 52.870		
24	Web	64.060Inches ± 0.030	64.090 64.030		
25	Web	70.270Inches ± 0.030	70.300 70.240		
26	Web	73.020Inches ± 0.030	73.050 72.990		
27	Web	75.770Inches ± 0.030	75.800 75.740		
28	Web	56.150Inches ± 0.030	56.180 56.120		

Plex 1/30/18 2:16 PM Dart.Gagnon.Michelle

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
2 SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171264

JAN 30 2010



NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.08		

RELEASED
2010-11-01

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D2739
TITLE WEB
SCALE NTS
REV. E
SHEET 1 OF 1

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